

Work Order ID 86566

86566

Page 1

July-05-12 10:41:16 AM

Item ID: D3272-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step
 Start Date: 7/05/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3272 | Rev B | | | | | | | | |

100 Large Fab 0.00
100
 Large Fab Memo 0.00
 Large Fab ***SQUARE ONE END BEFORE CUTTING OTHER END***
 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A
 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.
 3-Deburr
 110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00
 Quality Control

10 0 Ae 12-07-11
 10 0 12-07-12

Work Order ID 86566

86566

Page 2

July-05-12 10:41:16 AM

Item ID: D3272-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step
 Start Date: 7/05/12 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | Identify as per dwg & Stock Location: <i>WMA</i> | 0.00 | | | | <i>10</i> | <i>0</i> | | <i>1207-12</i> |
| *120* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 130 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MLJ 12/07/13

MLJ 12/07/13

Picklist Print

July-05-12 10:41:15 AM

Page 1

Work Order ID: 86566

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 7/05/12

Required Date: 7/20/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2622-120C Step Extrusion | | Manufactured | No | | | 100 | Each | 133.0100 | 1 | 10 | | As 12.07.11 | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL | 16.37 | |
| 46910 | 2 | |
| 64409 | 6 | |
| 66970 | 7.7 | |
| 68293 | 0.25 | |
| 72131 | 0.42 | |
| WA | 107.28 | |
| 81507 | 2.88 | |
| 83894 | 104.4 | |
| WA013 | 9.36 | |
| 75781 | 2 | |
| 77612 | 7.36 | |

10



| | | | |
|----------------------|--------------------------------|--|------------------------|
| DESIGN <i>qp</i> | DRAWN BY <i>js</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED

07.06.04

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

B

GENERAL NOTES:

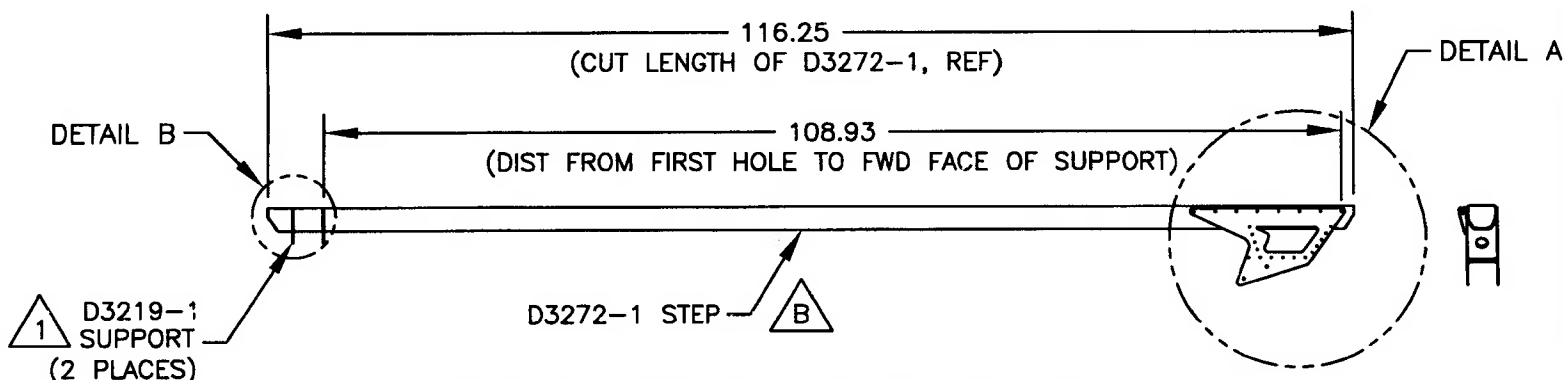
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

07.05.18

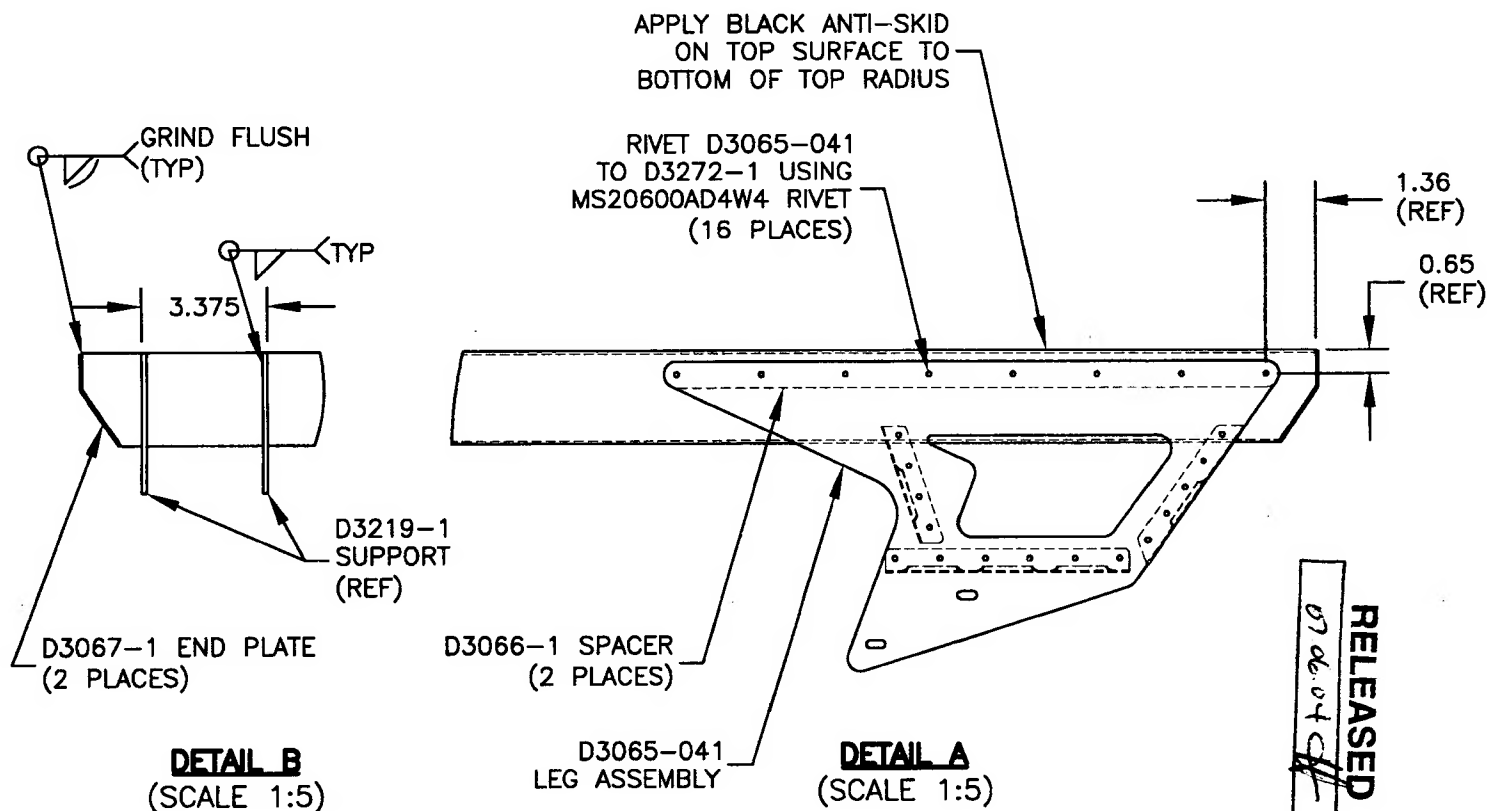
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART



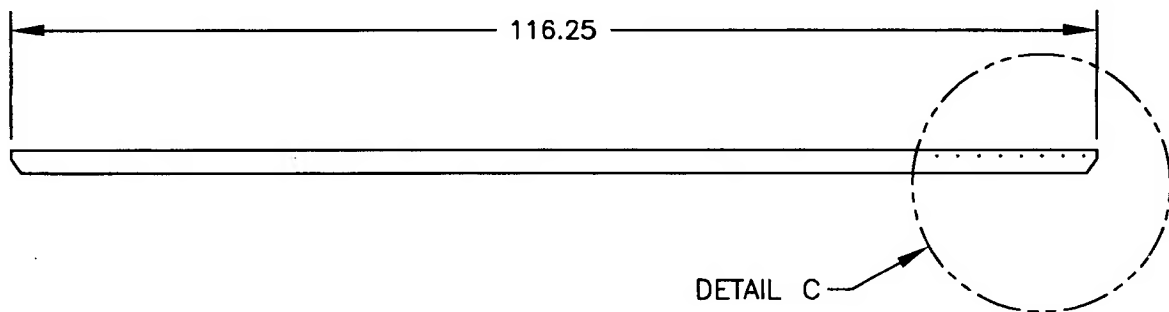
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



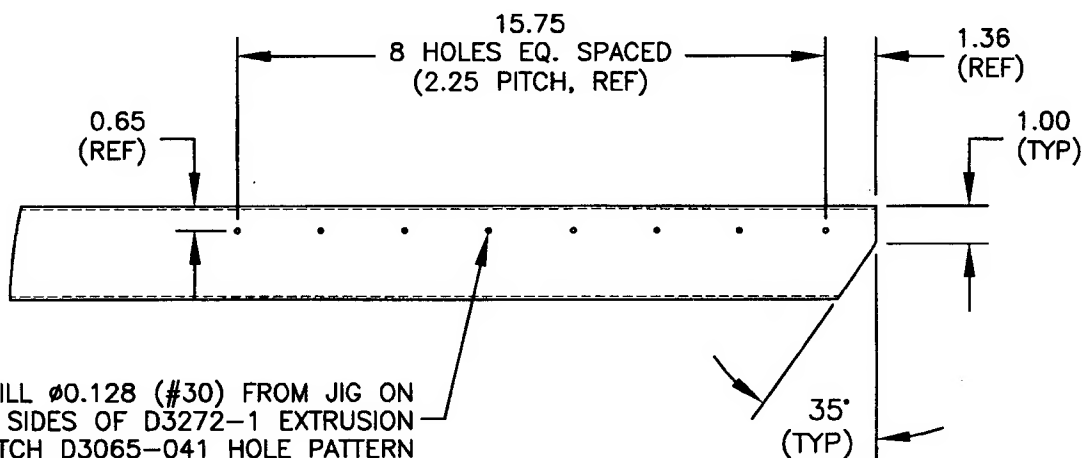
| | | | |
|----------|----------|------------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. B |
| CHECKED | APPROVED | DRAWING NO. | SHEET 2 OF 3 |
| DATE | | TITLE | SCALE |
| 07.05.18 | | STEP ASSEMBLY, HI LONG | 1:20 |



| | | | | |
|---------|----------|-------------|------------------------|-----------------------------|
| DESIGN | qf | DRAWN BY | JB | DART AEROSPACE LTD |
| CHECKED | CE | APPROVED | JB | HAWKESBURY, ONTARIO, CANADA |
| DATE | 07.05.18 | DRAWING NO. | D3272 | REV. B |
| | | TITLE | STEP ASSEMBLY, HI LONG | SHEET 3 OF 3 |
| | | SCALE | 1:20 | |



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

RELEASED
07.06.04